

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004481**Date Inspected:** 16-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Kuan Chung**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddle**Summary of Items Observed:**

The following report is based on METS observations at Japan Steel Works (JSW) in Muroran Japan. Current work: Casting, machining and repair of Saddles.

FOUNDRY SHOP

On this date the QA representative Dong J. Shin arrived at Japan Steel Works (JSW) of Muroran Japan and traveled to JSW foundry. QA Inspector observed the casting build up welding on West Deviation Saddle casting W2-E2. The welding was performed to build up the thickness of the ribs in areas that were found to not meet the minimum thickness of the contract special provisions. The repair locations and repair details for this casting were submitted as number 000643, revision 02. The JSW welding personnel Mr. Y. Kabutomori continued the in process build up welding of Rib8U, repair B-B, location B-4 build up weld process utilizing the Shielded Metal Arc Welding (SMAW) process per the welding procedure specification (WPS) SJ 3026-2. The welding was performed in the 2G (Horizontal) position. The filler metal utilized was identified as 5mm diameter, Class E10016-G, Brand name LB-106. The minimum preheat temperature of 160 degrees Celsius and maximum interpass temperature of 260 degrees Celsius was verified to meet the WPS requirements. The SMAW welding average amperage and voltage by clamp type meter and travel speed were verified to be within the welding procedure specification parameter range of 180 amps to 240 amps, 22 volts to 26 volts and travel speed of 115 to 280 mm per minute by the QA inspector. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and contract documents.

NDT Inspection (Foundry Shop)

On this date the QA representative Dong J. Shin observed NISC NDT Technician Mr. Wada Makoto and Mr.

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Kohama Harumi perform ultrasonic testing on Casting W2-E3. Ultrasonic testing was performed after rough machining. QA Inspector Mr. Dong Shin checked ultrasonic testing was performed by straight beam and angle beam testing and confirmed calibration date of ultrasonic testing unit, DAC curve and scanning pattern. Results were confirmed to be in accordance with approved Ultrasonic testing procedures.

FABRICATION SHOP # 4

Mr. Kobayashi and Mr. Nakasato performed welding on fill pass welds on E1Y-11V, E1Y-17V and E1Y-12V rib plate to rib plate and rib plate to stem plate of W2E1 casting to steel structure. The fill pass welding (FCAW) process per the welding procedure specification (WPS) SJ-3011-5 and SJ 3011-6. The welding was performed in the 2G (Horizontal) position. The filler metal utilized was identified as 1.6mm diameter, Class E90T5-K2C H4, Brand name TM 95K2. The welding parameters and heat control were monitored by Intertek Testing Services Quality Control (QC) inspector Mr. Chung-Fu Kuan at periodic intervals. The minimum preheat temperature of 160 degrees Celsius and maximum interpass temperature of 260 degrees Celsius was verified to meet the WPS requirements by Mr. Kuan and the QA inspector utilizing Tempilstik temperature indicators. This data was entered into the QC inspector's daily log, identifying the location on a weld map. The SMAW welding average amperage and voltage by clamp type meter and travel speed were verified to be within the welding procedure specification parameter range of 325amps to 350 amps, 35 volts to 38 volts and travel speed of 255 to 310 mm per minute for the 1.6mm Wire. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure specification and contract documents.

Mechanical Test

The QA inspector observed two each Side Bend tests for welder qualification tests for Toshiyuki Watanabe (08-5153) and Koetsu Shimozaawa (02-2889) per SW-1(SMAW 3G). The test was performed in accordance with AWS D1.5-2002 paragraph 5.18.3. JSW QC personnel Mr. Naoya Takahashi performed tests and recorded results as acceptable in accordance with paragraph 5.19.2.

Summary of Conversations:

No specific conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Lanz,Joe	QA Reviewer
